

Date: Monday, 02/03/2009 9:05:11 AM
 User: Julie Dawson

Process Sheet

split for qty 4 on this w/o:
 qty 16 remaining - 1
 09.03.16

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46145 -2
 Estimate Number : 10569
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 44586
 Written By :
 Checked & Approved By : JUD 09.03.02
 Comment : A 05.11.14 New issue EC

Drawing Name : STRUT WELDMENT ASSY

Part Number : D34437
 Drawing Number : D3443 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 16/03/2009

Qty: 4 Um: E

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M304TR0750W120

304 ss round tube .750 x .120w



(17x)

Comment: Qty.: 0.7875 f(s)/Unit Total: 15.7500 f(s)
 AISI 304 SS seamless tubing 0.750" OD x 0.120" wall
 (M304TR0750W120)
 Batch: M110672

M111097 (3x)

M-1 09/03/03

2.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE
 1- Form as per Dwg D3443 using DT8117
 2- Deburr per dwg D3443

FF 09-03-12

M-1 09/03/12

3.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 GRIND RAD PER DWG

M-1 04/03/12

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-13 (20)

5.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



(4)







Comment: CONVENTIONAL MILLING MACHINE
 1- Mill end to length and drill hole as per dwg D3443
 2-Deburr as per dwg D3443

N.A 09/03/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3443-7 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/03/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46145-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/12	1	at the set-up when forming flat parts one part was too much suppose to be .200 \pm .005 and put at .208 R.C process		put batch it on part keep to make D 3443.5 replace Qty 1	M.H 09/03/12	SB 09/03/12		
								

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 46145

Part Number: D34437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.A 09/03/14

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Sub 09/03/16 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A

EL 9-3-16 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

09/03/15

Job Completion



W 09.03.16

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$

1.05

**D3443-9 PIN****D3443-9 NOTES:**

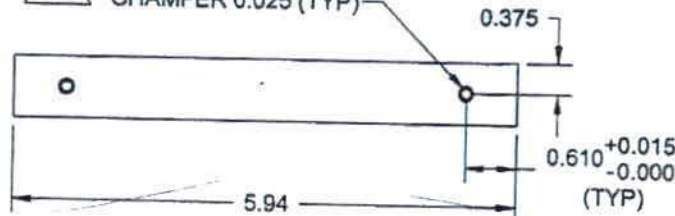
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

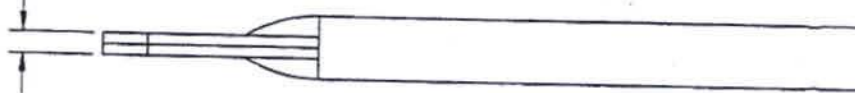
05.12.09



DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

**D3443-5 TUBING**

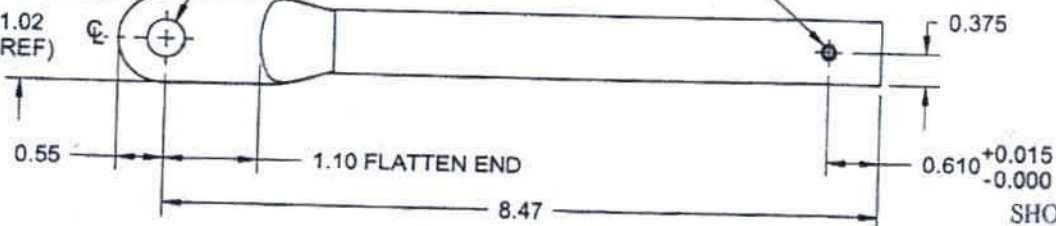
$0.260^{+0.000}_{-0.030}$



R0.51
 $\phi 0.438$
1.02 (REF)



DRILL $\phi 0.125$ THRU
CHAMFER 0.025

**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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NO. 4645

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